



Dart Aerospace Ltd.
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D4710-1

Job Sheet 181658



Part No: D4710-1

Job Qty: 50 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/3/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-09-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		8/17/18	0.00	0.00	Start Up Machining-3		
100	CNC Lathe	50 pcs		8/17/18	0.00	7.41	Doosan		
110	QC	50 pcs		8/17/18	0.00	0.00	QC2 Machining-3		
120	QC	50 pcs		8/17/18	0.00	0.00	QC8 Machining-3		
130	Packaging	50 pcs		8/17/18	0.00	0.00	Packaging3-2		
140	QC21-SA	50 Ea		8/17/18	0.00	0.00	QC21		

Part Op 100 - TURN AS PER DWG FOLIO REV: _____ DWG REV: _____ DEBURR

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINR1.500	Round Bar Delrin 1.5" Color: Black	1.5000 ft (.03 ea)	90-Start up Operation	M136552 M134549

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINR1.500	2	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.690Inches ± 0.010	0.700 0.680	Radius	.690
2	Spacer	0.395Inches ± 0.010	0.405 0.385	Radius	.394
3	Spacer	0.820Inches ± 0.010	0.830 0.810	Countersink, Diameter	.820
4	Spacer	90.000Degrees ± 0.500	90.500 89.500	Angle	90°
5	Spacer	0.600Inches ± 0.030	0.630 0.570		.596

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

6	Spacer	90.000Degrees $\pm$ 0.500	90.500 89.500	Angle	90°
7	Spacer	0.125Inches $\pm$ 0.010	0.135 0.115		0.125

Plex 8/3/18 9:08 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Dart Aerospace Ltd. 1270 Aberdeen Street Hewitsonbury, ON K6A 1K7 CANADA Tel: 513 832-5200 Fax: 513 832-5200 Email: sales@dartaero.com www.dartaero.com	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="text-align: center;">Water Jet</td> <td style="width: 20px; height: 20px;"></td> <td style="text-align: center;">Engineering</td> <td style="width: 20px; height: 20px;"></td> </tr> <tr> <td style="text-align: center;">1. Eng. Coord.</td> <td style="width: 20px; height: 20px;"></td> <td style="text-align: center;">Quality</td> <td style="width: 20px; height: 20px;"></td> </tr> <tr> <td style="text-align: center;">e/Packaging</td> <td style="width: 20px; height: 20px;"></td> <td style="text-align: center;">Other</td> <td style="width: 20px; height: 20px;"></td> </tr> <tr> <td style="text-align: center;">Supplier</td> <td style="width: 20px; height: 20px;"></td> <td></td> <td></td> </tr> </table>	Water Jet		Engineering		1. Eng. Coord.		Quality		e/Packaging		Other		Supplier			
Water Jet		Engineering																	
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Supplier																			
			MRB (QSI042) Approval																
			Completed By																
			Lead hand / Supervisor Approval Verification																
			QC / QA Coordinator Approval																

Root Cause			
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	Pressure/forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes
			Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center
			Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence

Container No: S113878 Part: D4710-1 Job No: 181658 Serial No/Batch: S113878
 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's
 Date: 09/26/16

OTHER :